

Date: Thursday, 07/05/2009 3:30:46 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SLIDING PLATE
Job Number : 47802	
Estimate Number : 11215	
P.O. Number :	Part Number : D33333 72
This Issue : 07/05/2009 S.O. No. :	Drawing Number : D3333 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : MACHINED PARTS	Drawing Revision : B
Previous Run : 47468	Material :
Written By :	Due Date : 22/05/2009 Qty : 30 Um : Each
Checked & Approved By : <u>JULIE DAWSON</u>	
Comment : Est. A05.01.13 New issue KJ/JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M1010B4000X00500	1010-1025 Steel Bar 4.00 x .500
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Comment: Qty.: 0.7984 f(s)/Unit Total: 23.9526 f(s) + 29.815 inches - Not removed from stock \$ 09/05/27

AISI 1010-1025 Steel Bar

Material: AISI 1010-1025 or ASTM A36/A366/A569/A570 Cold Rolled Steel

(M1010-B4.000x00.500)

Identify for D3333-3

Batch: 111741

DJP 09/05/25

(30)

2.0	BAND SAW	BAND SAW
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**Comment:** BAND SAW

Cut blanks: 4.000" x 0.500" thick x 9.620" long

DJP 09/05/25

(30)

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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**Comment:** HAAS CNC VERTICAL MACHINING #1

Machine as per Folio FA483 and Dwg D3333

Identify as D3333-3

\$ 09/05/27

(32)

A40 →

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--

**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

\$ 09/05/27

(32)

5.0	QC8	SECOND CHECK
-----	-----	--------------

**Comment:** SECOND CHECK

\$ 09/05/27 (32)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3333-3 PAR #: N/A Fault Category: Machining NCR: Yes No DQA: / Date: 09.06.24
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: / Date: 09.07.13

NCR: <u>47802</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09/05/26 <u>/</u>	3.0	Scrap 3 parts. Various Causes to created bad chamfers. R.C. Programming Problems parts lifting in vice due to setup in. Folio tapping was drawing parts out of vice.	<u>/</u> BS1412	Scrap and replace 3 parts B#111741 1-part scrap - threaded hole is counter sunk. 2- remaining parts even NCR are acceptable, will not interfere or affect the assembly.	<u>/</u> 09/05/26	<u>/</u> 09/05/27	<u>/</u> BS1412	<u>/</u> 09/05/27
			<u>/</u> BS1412		<u>/</u> 09/05/27	<u>/</u> 09/05/27	<u>/</u> BS1412	<u>/</u> 09/05/27

NOTE: Date & initial all entries

Date: Thursday, 07/05/2009 3:30:46 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SLIDING PLATE

Job Number: 47802

Part Number: D33333

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Deburr and Grind 45° chamfer on opposite side of pocket along edges as per Dwg D3333

SAD

09-05-28

(32)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SAD 09/05/28

count

(32)

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Fire Red (Ref: 4.3.5.10) as per QSI 005 4.3
Ensure to mask threaded holes and sides

START TIME: _____

OVEN TEMPERATURE: _____

FINISH TIME: _____

sent to Red Barn
29 is

W

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

Rec'd 6/14 (32)

SHIP

5-1410-722541

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/06/19

Job Completion



W 09/06/19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 47802
Description: Sliding Plate		Part Number: D3333-3
Inspection Dwg: D3333	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.900	+/-0.010	3.898	✓			
9.50	+/-0.030	9.499	✓			
0.650	+/-0.010	.645	✓			
2.310	+/-0.010	2.311	✓			
1.125	+/-0.010	1.126	✓			
1.950	+/-0.010	1.949	✓			
1.200	+/-0.010	1.198	✓			
1.300	+/-0.005	1.298	✓			
R0.125	+/-0.010	.125	✓			
0.500	+/-0.010	.498	N/A 09.05.26			
0.440	+/-0.010	.436				
1.675	+/-0.010	1.673	✓			
0.035 x 45°	+/-0.010 x 0.5°	.030 x 45°	✓			
0.485	+0.000/-0.010	.480	✓			
1.11	+/-0.030	1.112	✓			
3/8 - 24 UNF	N/A	3/8 - 24 UNF	✓			
0.450	+/-0.010	.448	✓			

Measured by: J	Audited by: G JB	Prototype Approval:	N/A
Date: 09/05/26	Date: 09/05/27	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	05.04.26	New Issue	KJ/JLM	
B	07.03.21	Dimensions added	KJ/JLM	BE

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

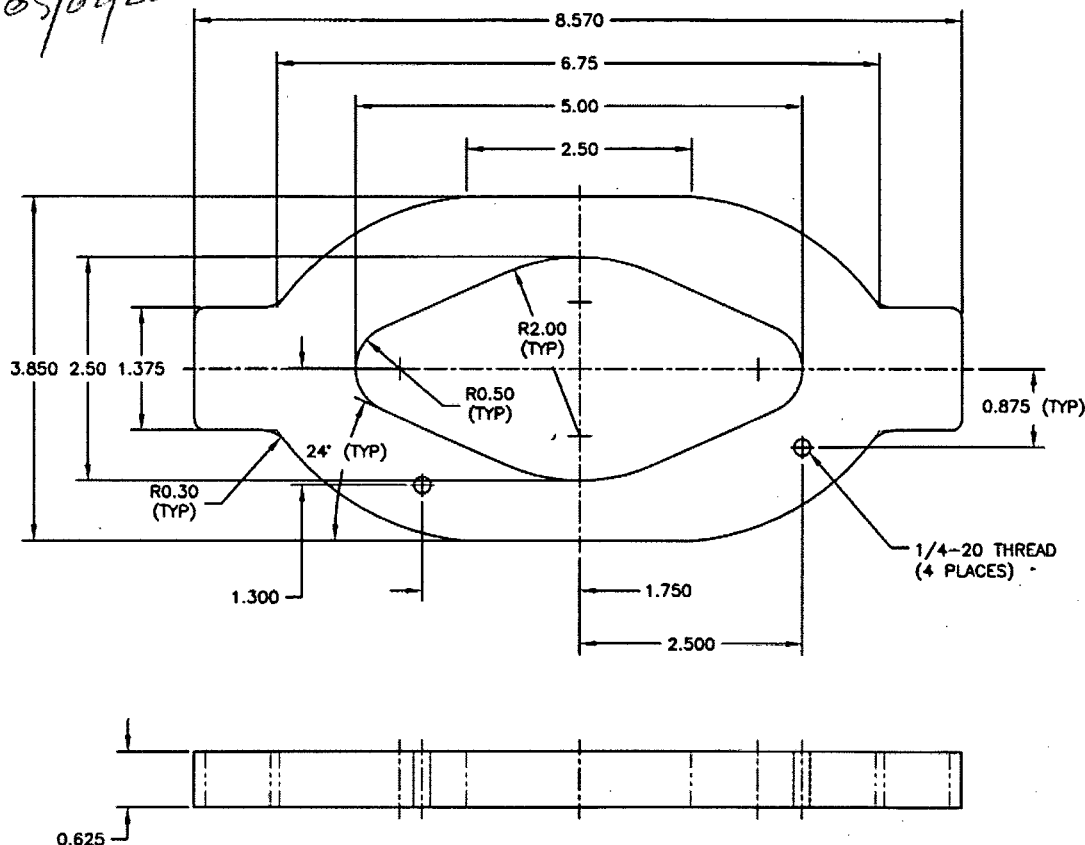
NOTE: Date & initial all entries



DESIGN F	DRAWN BY F	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 3	APPROVED [Signature]	DRAWING NO. D3333	REV. B SHEET 1 OF 3
DATE 05.02.18		TITLE PLATE	SCALE 1:2
A	04.12.14	NEW ISSUE	
B	05.02.18	RE-DESIGN D3333-3	

RELEASED
[Signature]

05/02/22



D3333-1 BASE PLATE PANEL

NOTES:

- 1) MATERIAL: AISI 4140 STEEL 0.625 THICK STEEL (REF. DART SPEC. M4140-B) MIN. YIELD TENSILE STRENGTH = 100 ksi
- 2) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005.4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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NO. 47802

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

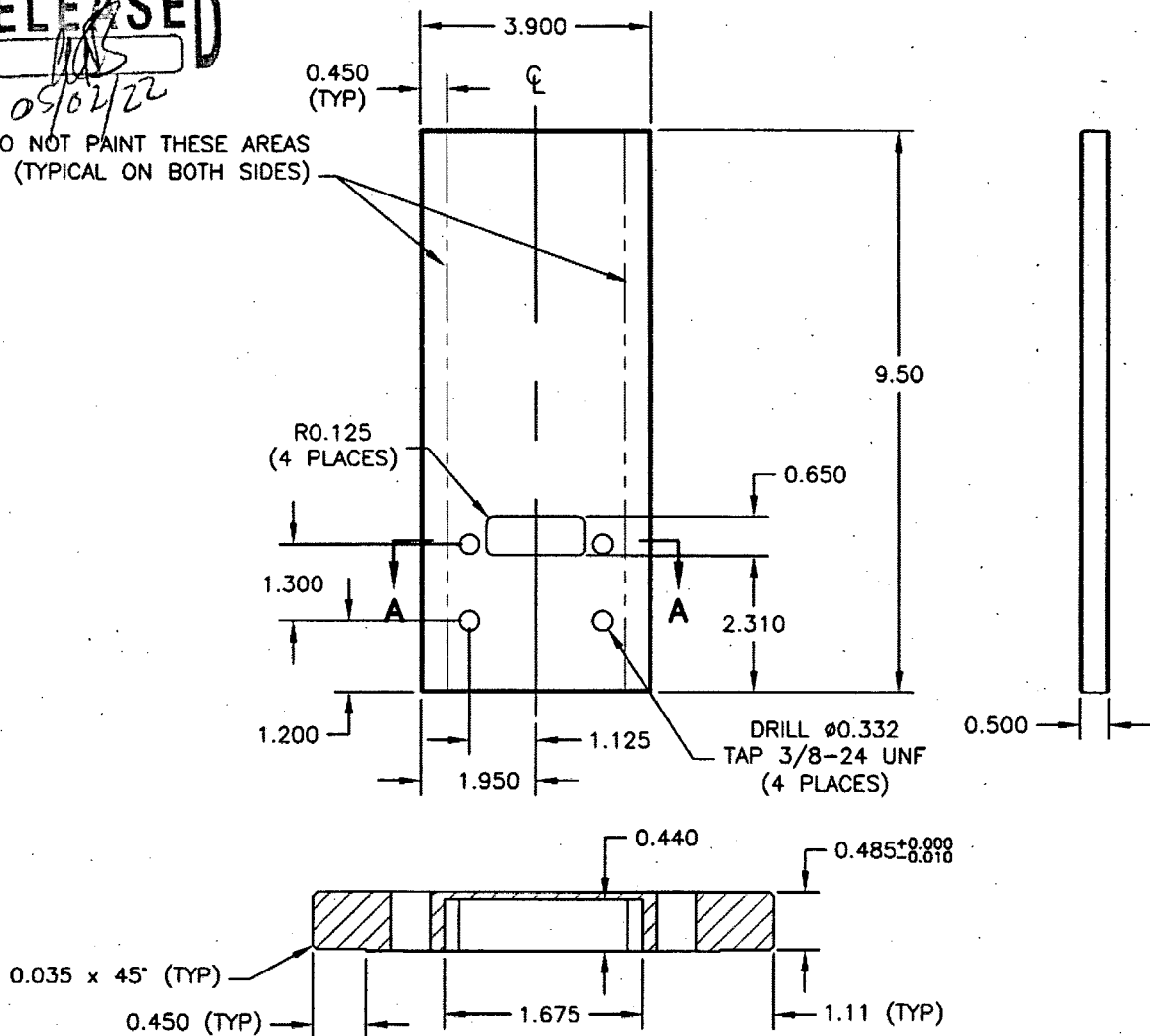
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN H	DRAWN BY H	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D3333	REV. B SHEET 2 OF 3
DATE 05.02.18		TITLE PLATE	SCALE 1:4

RELEASED
05/02/22DO NOT PAINT THESE AREAS
(TYPICAL ON BOTH SIDES)

SECTION A-A

D3333-3 SLIDING PLATE**NOTES:**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570, 0.50 THICK MILD STEEL (REF. DART SPEC. M1010-B)
- 2) FINISH: POWDER COAT FIRE RED (REF. 4.3.5.10) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

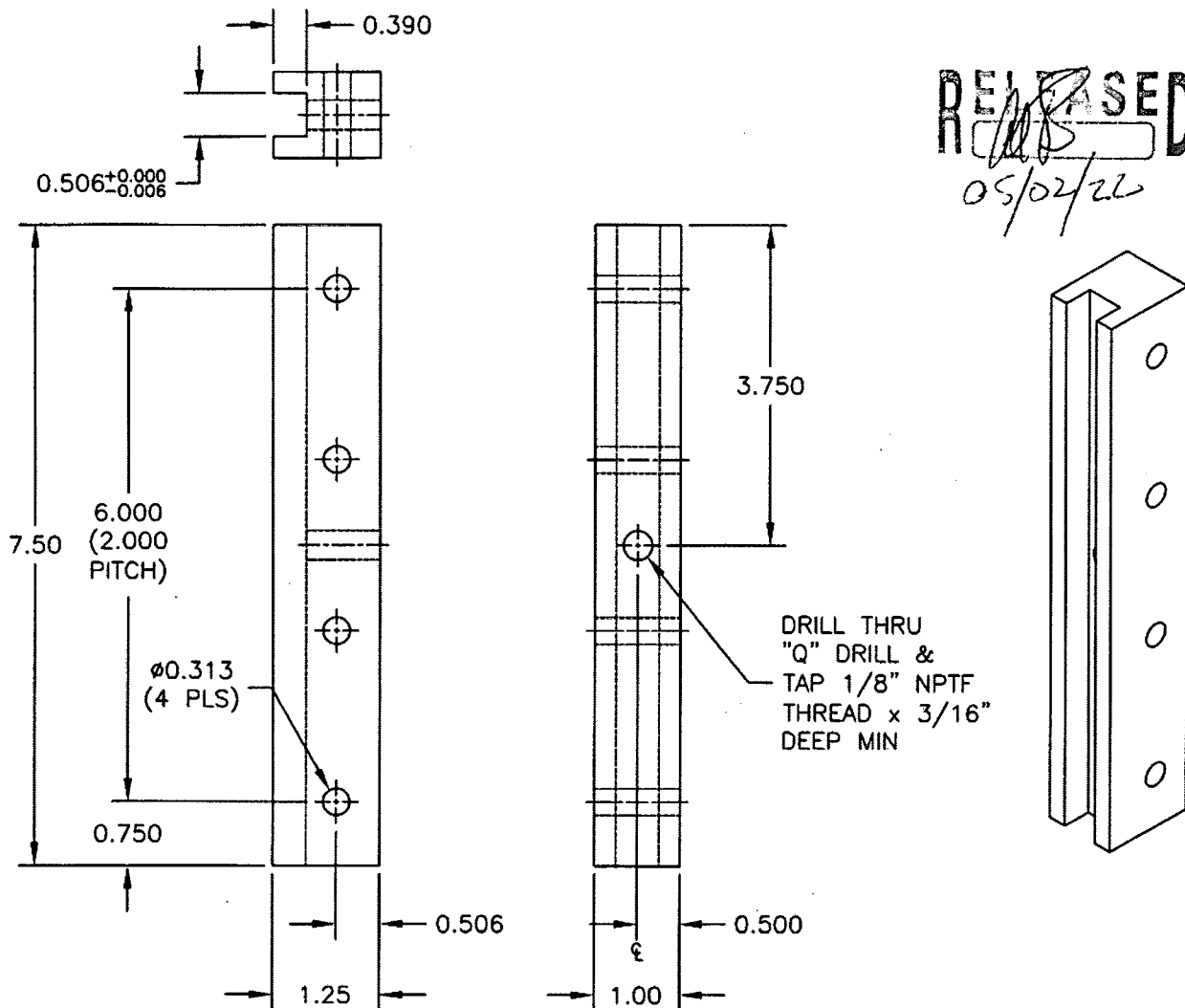
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3333	REV. B SHEET 3 OF 3
DATE 05.02.18		TITLE PLATE	SCALE 1:2

**D3333-5 RAIL****NOTES:**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570, 1.00 THICK STEEL (REF. DART SPEC. M1010-B)
- 2) FINISH: POWDER COAT FIRE RED (REF. 4.3.5.10) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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